

Work Order ID 78401***78401***

Page 1

Item ID: D350-589-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Door Latch Modification

Start Date: 09/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 23/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.C.J.Date: 12/01/09 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

INN-D350-589

E

***SP**

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

5/2/2017SP Form 12-2-15
(4)

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

SP 12-02-15

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

5/2/2017(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-589-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per QSI 014

NEVF

FG/22

130

0.00

130

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/2/12 (H)

12/2/21 (H)

R12-0217 (H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

January-09-12 8:56:27 AM

Page 1

Work Order ID: 78401

78401

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F02.08.29Removed D2587 PlugKJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10	NAS1149D0363J	Purchased	No			105	Each	0.0000	3	12			
-----------	---------------	-----------	----	--	--	-----	------	--------	---	----	--	--	--

S₄ *AN960.ID10*

Washer

D2237

Manufactured No

105 Each

64.0000

3

12

S₄ *D2237*

Striker Plate

**

**

Location

Loc Qty

Loc Code

ST006

64

66139

2

~~77046~~

35

~~77872~~

27

D2583

Manufactured No

105 Each

9.0000

3

12

S₄ *D2583*

Latch Bracket

**

Location

Loc Qty

Loc Code

ST011

9

76074

9

D2585

Manufactured No

105 Each

55.0000

3

12

S₄ *D2585*

Mounting Channel

**

Location

Loc Qty

Loc Code

ST011

55

73297

2

74488

9

~~77696~~

44

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 78401

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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 4.00

Required Qty: 4.00

D2586 Manufactured No

105 Each

13.0000 3 12

D2586

Door Latch

**

B77697 12x SP.

Location

Loc Qty

Loc Code

ST204

13

74489

13

D2587 Manufactured No

105 Each

12.0000 1 4

D2587

Door Slug, 350 Hinge

**

B78893 3x. SP

Location

Loc Qty

Loc Code

ST011

12

74522

12

D2589 Manufactured No

105 Each

36.0000 1 4

D2589

Keys, Key Chain, 350 Hinge

**

1x SP

Location

Loc Qty

Loc Code

ST011

36

58194

36

MS20470AD4-5 Purchased No

105 Each

3,359.000 6 24

MS20470AD4-5

Rivet, Universal Head

**

4x SP 12-02-15

Location

Loc Qty

Loc Code

ST319

3359

118405

1706

120142

1653

24x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 78401

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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

105

Each

6,189.000

3

12

MS21042L3

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

6189

117441

16

117885

32

118451

5

118927

3

119017

5610

119075

523

12x

MS27039-1-15

Purchased

No

105

Each

121.0000

3

12

MS27039-1-15

Screw

**

SP 12-02-15

Location

Loc Qty

Loc Code

ST291

121

118093

22

118574

2

119736

97

12x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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